

Work Order ID 78056

December-28-11 10:12:31 AM

78056

Page 1

Item ID: D412-785-003-403

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Pax Speaker Mount, Fwd

Start Date: 28/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.L.J

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D412-785-003-101

B

100

FLOW WATER JET

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

1311-12-29

4

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

1311-12-29

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8/11/2012

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78056

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Page 2

December-28-11 10:12:31 AM

Item ID: D412-785-003-403 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pax Speaker Mount, Fwd
 Start Date: 28/12/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	c'sink as per dwg								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									

Handwritten: 12/01/05 (4)

Handwritten: 8/2/05

Handwritten: (4)

Handwritten: 12-01-05

Handwritten: 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 78056***78056***

Page 3

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Pax Speaker Mount, Fwd

Stop ***NS2***

Start Date: 28/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: 137	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

ME
12-01-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

December-28-11 10:12:35 AM

Page 1

Work Order ID: 78056

78056

Parent Item: D412-785-003-403

D412-785-003-403

Parent Item Name: Pax Speaker Mount, Fwd

Start Date: 28/12/2011

Required Date: 05/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 11-09-01 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.040

Purchased

No

sf

31.3184

0.526316

2.5

M2024T3S 040

**

1811-12-29

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

31.318421

117684

31.318421

117684

(4)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

TRANSFER DRILL 4X Ø0.203 HOLE FROM
D412-785-003-201/-203 SPEAKER MOUNT TO AIRFRAME
TRANSFER DRILL 8X Ø0.098 HOLES FROM
MS21069L3 ANCHOR NUTS (CENTERED ON
PREVIOUSLY DRILLED HOLES) TO AIRFRAME
COUNTERSINK 8X Ø0.179 X 100°
ATTACH MS21069L3 ANCHOR NUTS USING
MS20426AD3-4 RIVETS
ATTACH D412-785-003-201/-203 SPEAKER
MOUNTS USING AN525-10R7 TO MS21069L3
ANCHOR NUTS
6 PLACES TYP

PASSENGER ADDRESS SPEAKER
ATTACH USING MS27039-806

ITEM NO.	QTY. -101	PART NO.	DESCRIPTION
1	4	D412-785-003-201	SPEAKER MOUNT
2	2	D412-785-003-203	SPEAKER MOUNT
3	6	TR650-Cxi	SPEAKER
4	24	AN525-10R7	SCREW
5	24	MS27039-806	SCREW
6	24	MS21069L3	ANCHOR NUT

SHOWN BY
REFERENCE
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITH NOTICE
WORK ORDER
NO. 78056 M.C.J.
11/12/28

D412-785-003-101 PASSENGER SPEAKER MOUNT INSTALLATION

D412-785-003-201
SPEAKER MOUNT AFT SHOWN
4 PL
D412-785-003-203
SPEAKER MOUNT FORWARD SIMILAR
2 PL

CABIN ROOF
REF

SPEAKERS MOUNTED
IN LIGHTENING HOLES
AT THESE LOCATIONS

STN 84

STN 110

STN 139

BL +36

BL 0.0

BL -36

D412-785-003-203
2 PL

D412-785-003-201
2 PL

D412-785-003-201
2 PL

RELEASED
2010-08-20

B	UPDATE FOR LSTC	HS	09.10.09
A	NEW ISSUE	HS	08.12.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RN	EAGLE COPTERS MAINTENANCE CALGARY, ALBERTA, CANADA	
DRAWN	HS	DRAWING NO.	REV. B
CHECKED	N/A	D412-785-003-101	SHEET 1 OF 5
MFG. APPR.	N/A	TITLE	SCALE
APPROVED	HS	PAX SPKR MOUNT	NTS
DE APPR.	N/A	COPYRIGHT © 2008 BY EAGLE COPTERS MAINTENANCE THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM EAGLE COPTERS MAINTENANCE LTD.	
DATE	09.10.09		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

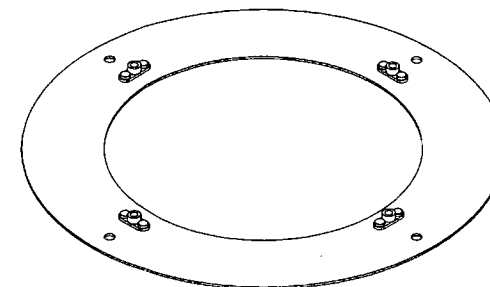
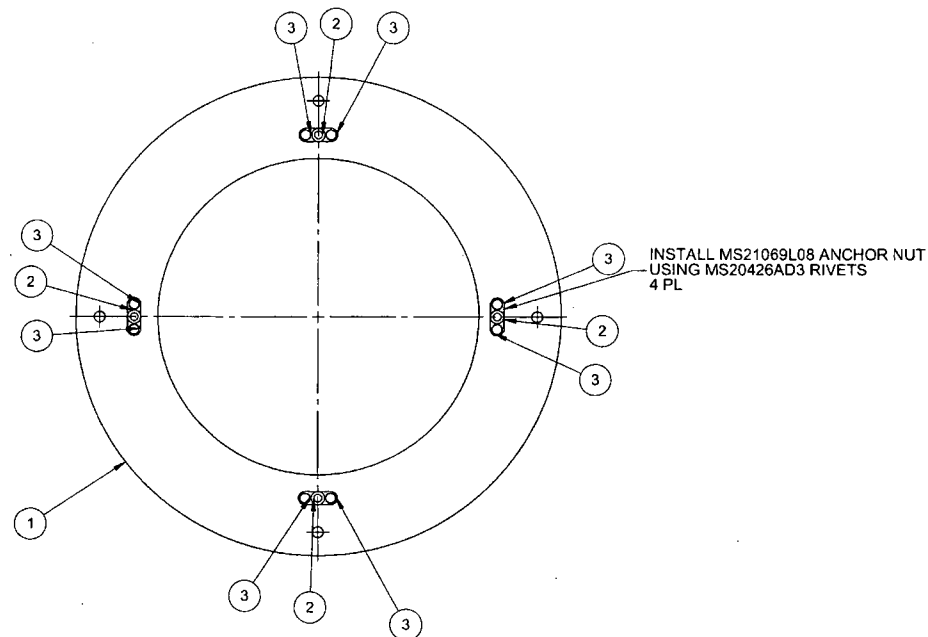
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78056

ITEM NO.	QTY. -201	PART NUMBER	DESCRIPTION
1	1	D412-785-003-401	PAX SPKR MOUNT, AFT
2	4	MS21069L08	ANCHOR NUT
3	8	MS20426AD3-4	RIVET



D412-785-003-201 PAX SPEAKER MOUNT AFT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: IDENTIFY WITH DART P/N D412-785-003-201 USING FINE POINT PERMANENT INK MARKER
- 6) WEIGHT: 0.13 lbs

RELEASED
2010-08-25

DESIGN	RN	EAGLE COPTERS MAINTENANCE	
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CHECKED	RE	DRAWING NO.	REV. B
MFG. APPR.	N/A	D412-785-003-101	SHEET 2 OF 5
APPROVED	RE	TITLE	SCALE
DE APPR.	N/A	PAX SPKR MOUNT	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

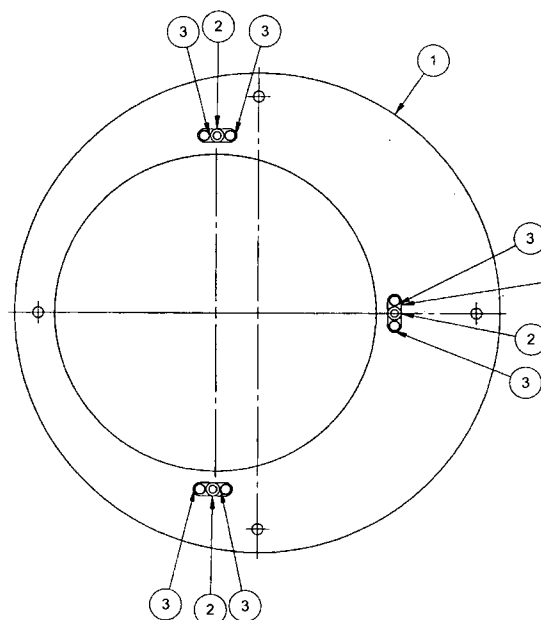
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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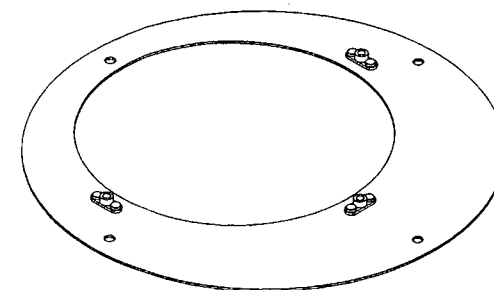
NOTE: Date & initial all entries

78056

ITEM NO.	QTY. -203	PART NUMBER	DESCRIPTION
1	1	D412-785-003-403	SPEAKER MOUNT, FWD
2	3	MS21069L08	ANCHOR NUT
3	6	MS20426AD3-4	RIVET



INSTALL MS21069L08 ANCHOR NUT
USING MS20426AD3 RIVETS
3 PL



D412-785-003-203 PAX SPEAKER MOUNT FWD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: IDENTIFY WITH DART P/N "D412-785-003-203 USING FINE POINT PERMANENT INK MARKER
- 6) WEIGHT: 0.05 lbs

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2010-08-25

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	D412-785-003-101	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	PAX SPKR MOUNT	NTS
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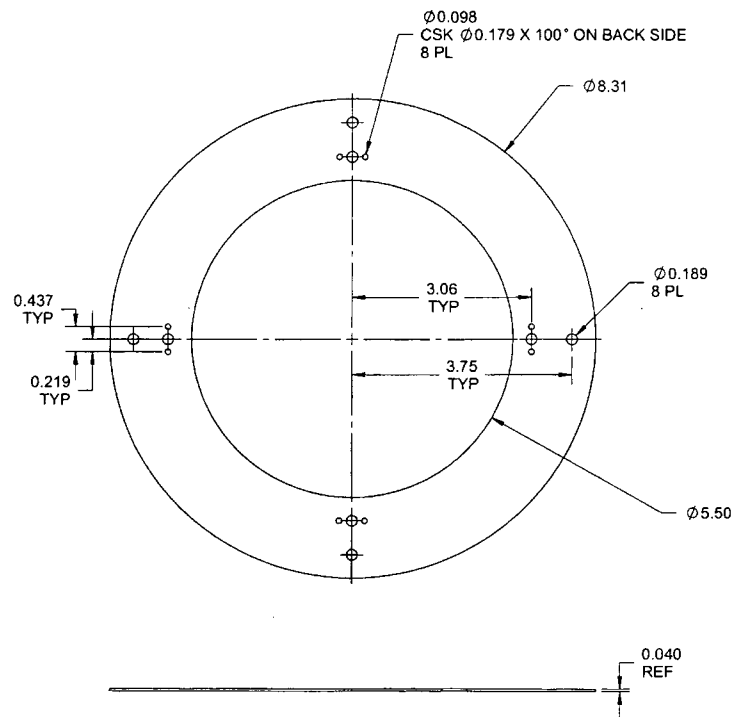
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

78056






D412-785-003-401 PAX SPEAKER MOUNT AFT

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
- 2) FINISH: ALODINE, PRIME AND PAINT PER BHT-412-MM
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 5) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

RELEASED
2010-08-25

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DRAWN		CALGARY, ALBERTA, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	D412-785-003-101	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.	N/A	PAX SPKR MOUNT	NTS
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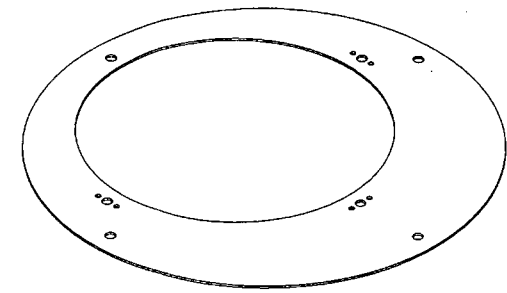
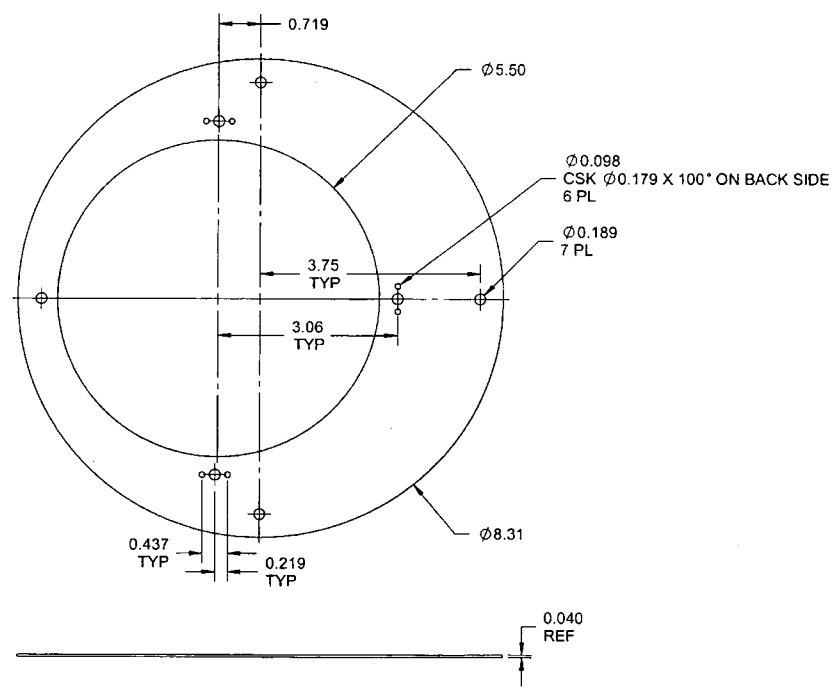
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D412-785-003-403 PAX SPEAKER MOUNT FWD

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/4 OR AMS 4037
 - 2) FINISH: ALODINE, PRIME AND PAINT PER BHT-412-MM
 - 3) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 5) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.04 lbs

RELEASED
2010-08-25

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DRAWN	<i>ES</i>	CALGARY, ALBERTA, CANADA	
CHECKED	<i>RL</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	D412-785-003-101	SHEET 5 OF 5
APPROVED	<i>CS</i>	TITLE	SCALE
DE APPR.	N/A	PAX SPKR MOUNT	NTS
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Measured by: 18	Audited by: S	Date: 11/12/21
Date: 11-12-21		
Rev	Date	Change
A	New Issue	Revised by: Approved
		KJULM